Work Orde	er ID 10780 9:04:49 AM		121-141	*107	' 801*							Page 1
Revision ID:	D3121-141 Bracket Assembly	В	107801	Accept	*N900	<u>)</u> 040	100	ገ*	-	Start Stop	*N:	S1* S2*
Start Date: Required Date: Reference:		art Qty: 16.00 q'd Qty: 16.00	*16* *16*		Cust Item Customer:					~	14.	12
Approvals:	Process Plan:	MLJ	Date: 13-10-03	Tooling:	D	Date:				Start	*NI	R1*
	QC:	- mathematical and a second and	Date:	SPC (Y/N):	С	Date:				Stop	*NI	R 2*
Sequence ID/ Work Center IE		eration cription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rejec		Reject Number	Insp. Stamp
Draw Nbr	Revision	Nbr										
D3121	Rev E'	-										
*100 *100* Bandsaw Jeaspa Bandsaw	BAN	ND SAW . Memo Cut blanks: ((1.250" x 2.000") 6.600" lon	0.00 0.00 g	£13	,-10-15	jø Tis	16	Ø			
*110 *110* HAAS 1 HAAS CNC vertical			MACHINING #1 D3121-111 as per Folio FA363-Scribe batch number	0.00 0.00 61 and Dwg D3121Iden	F 40 9-89	0/10/19	\ <u>\</u>	D&1	_ (3	() -17	(A)
120 *120*	QC2	2- Inspect parts off m	achine FAI/FAIB	0.00			. D.	<u> </u>	. –		. 7	
QC Quality Control		Memo		0.00			×	: <u>:</u>	13-	10	17	

NCR:	Yes	-	No
INC.IN.	153	,	1111

WORK ORDER NON-CONFORMANCE / UPDATE

DOA: SUTE	Date: 13/11/12
ihl	2///12

													QA Closed	VI Date		3/// 13
Work Orde	r: <u>/</u>	3 <i>7 8</i> 0	21				DISPOSITION				AGAINST D	EP	ARTMENT	/PROCESS		
	o. <u>D</u>	3121-	-141			Rework Scrap X Use-as-is Work Order Update			1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Desci	ript	tion of work order update		nitial	Act	tion	T	Sign &			
Cause	Da	e S	Step	Qty			Non-conformance	Ch	ief Eng	Desci	ription		Date	Verification		QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	(3-1) Y)) \$1·e	0,	¥(Spiso by Cfsa medi	+	under sized, out" renowed too much		DAS 12 2-89	SCRAP/ m 126806	REPLACE		3-10-18 13-10-18	3/10/18		13/10/16
опарриотес					i		F/	AUL	T CATE	<u> </u>		_				
Landir	ng Gear						General			7,572 7,000	**************************************					
	Bend Cent Crac	e Not C		itric to (o/s		Bend BOM/Route Broken/Damaged Burrs		i '	re on Incomplete ions Incomplete/l	Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi	ot _], V	ressure/Forced emperature/Cure Veld Vrong Stock Pulled
	Cuiffs		pcu			<u> </u>	Contamination Countersink		Mainte Mislabe	nance			Part Moved Positioned V	_	<u> </u>	-
	Insp	ction St	trip in	Tube			Cut Too Short		Misread	1			Power Loss/	Surge	C	Other
	_ ``	es in Be			<u> </u>	—	Drill Holes	X	Offset			_				
				xtrusio	n L	_	Drawing		4	Calibration		-				
		ng Sequ			L	—	Finish	<u></u>	4	Sequence		-				
	Wav	/Twist	in Tub	e	ų. 1		Folio	<u></u>	Outside	Dimensions						

Work Orde October-03-13		7801			×	107	RN1*						Page 2	
Item ID: Revision ID: Item Name:	D3121-141 Bracket Asser	nbly		A	Accept		*N900	040	100)* s	etup Star Stop	, IV	S1* S2*	
Start Date: Required Date: Reference:	10/03/13 10/17/13	Start Qty: 16.00 Req'd Qty: 16.00		*16* *16*			Cust Item I Customer:	D:			·	įW	. 7/	
Approvals:		ìn:	Date:		Toolin			ate:		R	un Star		R1* R2*	
Sequence ID/ Work Center II 130 *130* QC Quality Control)	Operation Description QC8- Inspect parts - secon	nd check		Set Run 0.00	Up/ Hours DAS 27 9-89 15 11, 1	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	-
140 * 1 <u>4</u> 		Small Fab Memo Assemble D3	121-141 as pe	r Dwg D3121	0.00	. , , K	APS			-13X-,			13/11/04	DAS 36 9-89
150 *150* QC		QC5- Inspect part complete	teness to step	on W/O	0.00	DAS 27 9-89				13			-	

B1105

Quality Control

NCR:	Yes	1	No
INCh.	162	1	INU

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: hot Date:	12/ulx11
DQA: MOY (Date:	13/11/19
$\frac{1}{2}$	12/11/12

										QA Closed(Date:	(4/1/1)
Work Order:	1178	11			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No		1-141			Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining Moforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	13/10/19	110		1 Part 1 Part	is old. Min size is . 382 Min size is . 389 Min size is . 390 Min size is . 391 Min size is . 391 Min size is . 391	9	048 12 89 3/11/1	BOTTCH M1268	week-eve. 806 I for	12 289 15/11/1	DAS 27 9-89]3/ d -1	13/10/21
		L .:	1		F	AUL	T CATE	GORY		l '	<u> </u>	
Landing	Gear				General							
	Bending Centre No Cracks Crushed/6		ntric to	o/s	Bend BOM/Route Broken/Damaged Burrs		•	ire ion Incomplete tions Incomplete/	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Cuffs Heat Trea	•			Contamination Countersink		Mainte Mislabe	enance		Part Moved Positioned V		J. C.
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes		Offset					
	Torque W	aves in E	xtrusio	n [Drawing		Out of 0	Calibration				
L	Turning S	•			Finish		Out of S	Sequence				
	Wave/Tw	ist in Tul	oe		Folio		Outside	Dimensions				

Work Ord		7801		*107	7801*							Page 3
item ID: Revision ID:	D3121-141			Accept	*N900	040	100)*	Setup	Start Stop	*N:	S1*
Item Name: Start Date: Required Date: Reference:	Bracket Asser 10/03/13 : 10/17/13	Start Qty: 16.00 Req'd Qty: 16.00	*16* *16*		Cust Item I Customer:	D:				·	^N	S2*
Approvals:		an:	Date:	Tooling: SPC (Y/N):		ite:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II	D	Operation Description Identify as per dwg & Sto	ck Location: 8123	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp DAS 26
160 Packaging Packaging	. ·	Memo		0.00								3-11-5
170 *170*		QC21- Final Inspection -	Work Order Release	0.00					4	A-/	/ Pm	13/11/2-
QC		Memo		0.00					- 4)/	4/41.	10/11/0

Quality Control

13/11/07 -MF (3-11-05)

DQA:Date:		D	QA:	Date:	
-----------	--	---	-----	-------	--

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

WCK.	es / NO					COIVE		MARKEL / OI		QA Closed:	Date	:
Work Orde	r:				DISPOSITION		•		AGAINST DE	PARTMENT	/PROCESS	
Part N			· · · · · · · · · · · · · · · · · · ·		Rework Scrap		ľ	Skid-tube Aachining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0				Use-as-is Work Order Update	$\frac{1}{2}$		oforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Init	ial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	_								:			
quip/Tooling												
Operator												
Material												
Setup												
Other												•
rocess] [
Supplier		l										
Training												
Jnapproved												
					F	AULT (CATE	ORY				
Landin	ng Gear				General							
. [Bending				Bend	Gr	rain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	BOM/Route	На	ardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Ins	specti	on Incomplete		Part Incorred	ct	Weld
	Crushed/	Crimped			Burrs	Ins	struct	ons Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	М	ainte	nance		Part Moved		_
	Heat Trea	at			Countersink	Шм	islabe	led		Positioned V	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short	М	isread			Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes	Of	ffset					
	Torque V	Vaves in E	Extrusion	n [Drawing		ut of C	Calibration				
	Turning S	Sequence			Finish		ut of S	equence				
Ī	Wave/Tw	vist in Tul	ре		Folio	По	utside	Dimensions		<u> </u>		

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 1

Work Order ID: 107801

107801

Parent Item:

D3121-141

D3121-141

Parent Item Name:

Bracket Assembly

Start Date: 10/03/13

Required Date: 10/17/13

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev:Pick:A04.02.18New issueKJ/DS

IPP Rev:B ECN 1060 07-11-12 DD verified by: EC

IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Sta	atus
[*] D3121-241	11*	Manufactured	No			100	Each	42.0000	1	16	13/1	DAS 36	
Bearing Assembly	+ 1										13/11	/04989	
				Locatio	<u>n</u>	Loc	Oty	Loc Code					
•				FG			14			-			
					89826		4		_			10.10	_
					95927		10		_		- 60	1077711	(1)
				ST235			24				_		(10
					105620		24				_		
				ST235A			4						
					102098		2				_		
					102693		2				_	. /	
D3121-21		Manufactured	No			140	Each	28.0000	1	16	,	/ /	DAS
*D3121-21	 *								**		13/	1/04	DAS 36 9-89
Boit				Location		Loo	<u>Qty</u>	Las Cada	_		10/	7	
					<u>u</u>	Luc		Loc Code					
				ST235	102052		28		_		_		
					102053		1		_		_		
					102765 105619		์ วว		_		- L	10716	1
					99292		22 4		_	 	- <i>!</i>)	10 7/6	4
					<u>.</u>		₹				_	(BW)	\

						į.					DQ	A: Da	ate: _	
NCR: Yes / No				WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:										
Mark Ord	or:					DISPOSITION				AGAINST D		NT/PROCESS		
Part No NCR No				Scrap Machining Small Fab Use-as-is Thermoforming Finishing		Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other				
Root					Descri	tion of work order update	T	Initial	Act	tion	Sign &			*
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	on	QC Inspector
Doc/Data	П										.*			
Equip/Tooling														
Operator														
Material	П						1							
Setup			Ì								İ			
Other					1									
Process								:		٠.				
Supplier			ŀ											
Training														
Unapproved						·			-					
						, F	AUI	LT CATE	GORY					
Landi	ng C	ear				General		_						
Bending			Bend	L	Grain	•	L	Ovalized			Pressure/Forced			
Centre Not Concentric to O/S		BOM/Route	L	Hardwa	re		Over/Und	der tolerance		Temperature/Cure				
		Cracks				Broken/Damaged	L	Inspecti	ion Incomplete	L	Part Inco	rrect	<u></u>	Weld [·]
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost,	/Missing	<u></u>	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Mov	ed		
		Heat Trea	at			Countersink		Mislabe	eled		Positione	d Wrong		
Inspection Strip in Tube			Cut Too Short		Misread			Power Lo	ss/Surge	1 (Other			

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes

Drawing

Finish

Folio

Picklist Print

October-03-13 9:04:53 AM

Work Order ID: 107801

Parent Item:

D3121-141

Parent Item Name: Bracket Assembly

107801

D3121-141

Start Date: 10/03/13

Required Date: 10/17/13

Start Qty: 16.00

Required Qty: 16.00

M174B1.250X02.000

17-4 SS Bar 1.250 x 2.00

Purchased

No

140

36.8000

0.55 **

Af 13-10-15 9.300'

Location Loc Qty MAT049 36.8 114899 2 M126132 12.45 M126806 22.35 Loc Code

9.3001

+ 2.8

									DQA	i: Dá	ate:		
NCR: Yes / No				WORK ORDER NON-CONFORMANCE / UPDATE									
										QA Closed	l: Da	ate:	
Work Orde	ar.				DISPOSITION				AGAINST DE	PARTMEN	T/PROCESS		
Work Orde					Rework	1		Skid-tube	Crosstube	1	Water Jet	: 🗀	Engineering
Part N	lo				Scrap	1		Machining	Small Fab	Pr	od. Eng. Coor		Quality
	•				Use-as-is			oforming	Finishing	Rec/St	ore/Packaging	\blacksquare	Other
NCR N	lo		······································		Work Order Update]		Large Fab	Composite]	Supplier	r	
Root				Descri	ption of work order update		nitial	Act	tion	Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	on	QC Inspector
Doc/Data		1	•										
Equip/Tooling													
Operator										1			
Material							1						
Setup													
Other												j	
Process													
Supplier													
Training													
Unapproved													
					F	AUL	T CATE	GORY					
Landii	ng Gear			_	General		1			7		_	i
H			Bend	lacksquare	Grain		<u> </u>	Ovalized			Pressure/Forced		
├		BOM/Route	<u> </u>	Hardwa			- 1 `	er tolerance	Ш	Temperature/Cure			
		Broken/Damaged	L	4 '	on incomplete		Part Incorr		_	Weld			
Crushed/Crimped		Burrs	\perp	-	ions Incomplete/	Unclear	Part Lost/N	•	\Box	Wrong Stock Pulled			
Cuffs		Contamination		Maintenance			Part Move						
	Heat Tre				Countersink		Mislabe	led		Positioned	_		•
	Inspection	n Strip in	Tube	L	Cut Too Short		Misreac	l	L	Power Loss	s/Surge		Other
	Rinnles i	n Bend		1	Drill Holes	Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



DE	DESIGN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
СН	ECKED	APPROVED	DRAWING NO. REV. E			
	4		D3121 SHEET 1 OF 10			
DA	ΓE		TITLE SCALE			
07	7.11.07		BRACKET ASSEMBLY 1:2			
Α		02.04.15	NEW ISSUE			
E	3	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146			
	;	04.02.17	ADD CLEARANCE; USE -241 BEARING			
)	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000			

RELEASE

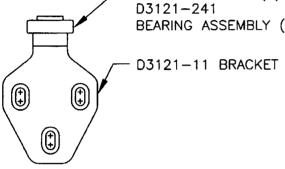
- D312	1-21	BOLT	(1)
D312	1-24	1		
BEAR	NG AS	SSEME	BLY	(1)

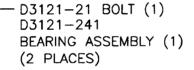
D3121-041 BRACKET ASSEMBLY

07.11.07

(REPLACES PREMIER P/N B30-23000-33)

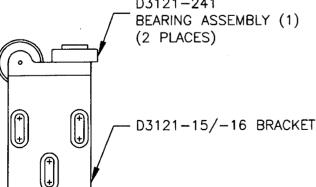
ADD TOLERANCE TO 0.032 (DETAIL B)





D3121 - 13/-14**BRACKET**

D3121-21 BOLT (1) D3121-241 BEARING ASSEMBLY (1)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY

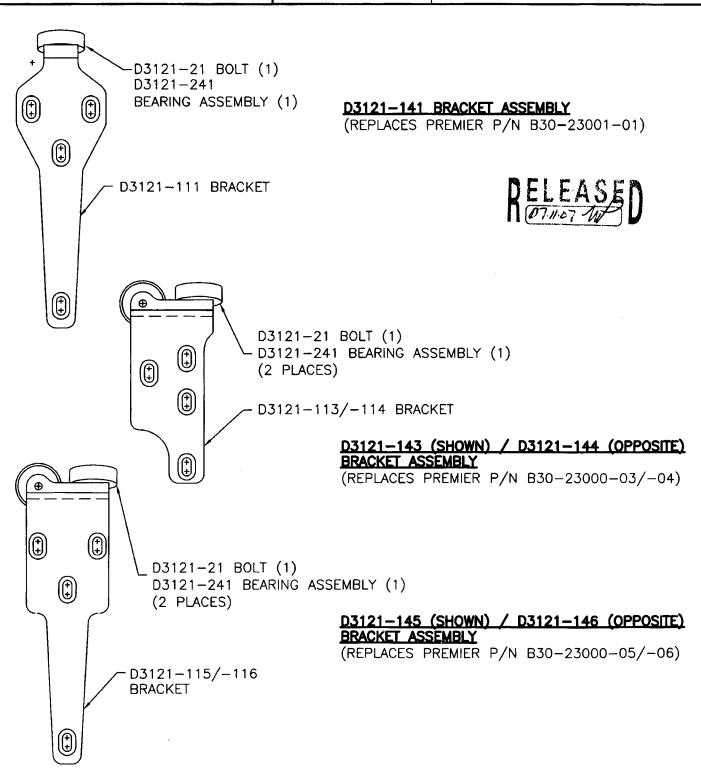
(REPLACES PREMIER P/N B30-23000-37/-38)

/ D3121-046 (OPPOSITE) D3121-045 (SHOWN) BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-35/-36)



DESIGN	DRAWN BY	DART AEROSP HAWKESBURY, ONTAR	
CHECKED	APPROVED	DRAWING NO.	REV. E
#		D3121	SHEET 2 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:2

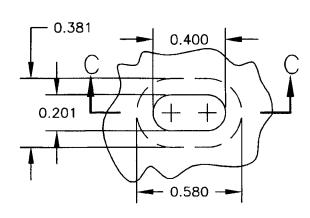


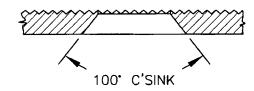
Copyright © 2002 by DART AEROSPACE LTD



DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	APPROVED,	DRAWING NO.	REV. E
4	-#	D3121	SHEET 3 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:1

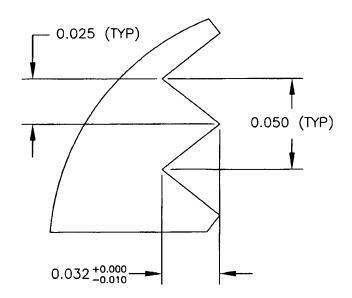
DETAIL A: SLOT DETAIL SCALE 2:1 VIEW ROTATED





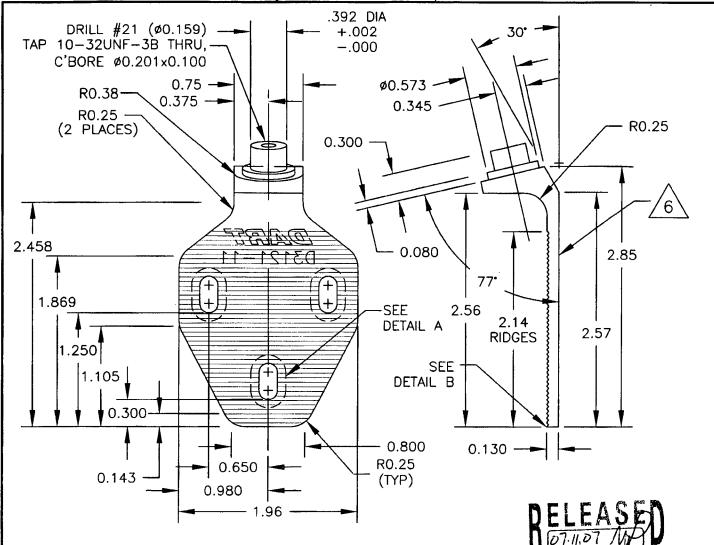


DETAIL B: RIDGE DETAIL PARTIAL SECTION SCALE 1:20





DESIGN	DRAWN_BY	DART AEROS HAWKESBURY, ONT.	
CHECKED	APPROVED	DRAWING NO.	REV. E
4	-	D3121	SHEET 4 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:1,

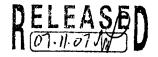


D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE = 150 ksi MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005



DESIGN	DRAWN BY	DART AEROSP HAWKESBURY, ONTAR	
CHECKED	APPROVED	DRAWING NO.	REV. E
4	- ##	D3121	SHEET 5 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:2



0

DART

D3121-13

1.220 - 1.800 -

 \bigcirc

 \bigoplus

SEE

2.63

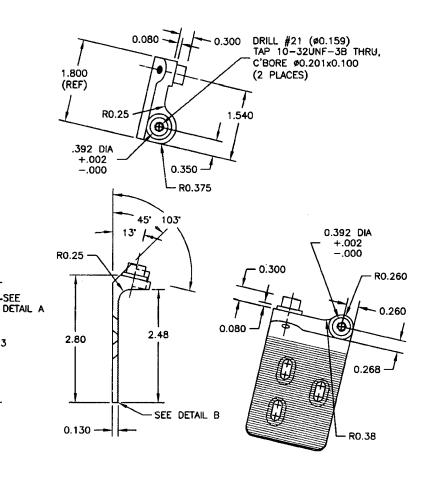
<u>6</u>

0.400

1.280

0.960

0.330 -



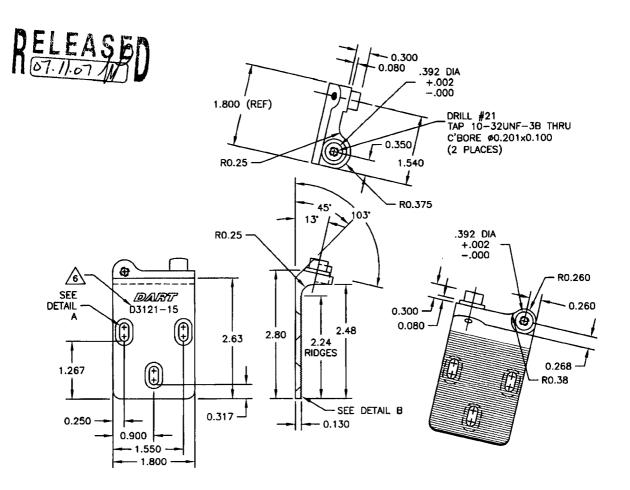
D3121-13 BRACKET (SHOWN) D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE STRENGTH = 150 ksi MIN YIELD TENSILE STRENGTH = 100 ksi
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

Copyright @ 2002 by DART AEROSPACE LTD



DESIGN # DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECKED	APPROVED	DRAWING NO.	REV. E		
9#		D3121	SHEET 6 OF 10		
DATE		TITLE	SCALE		
07.11.07		BRACKET ASSEMBLY	1:2		

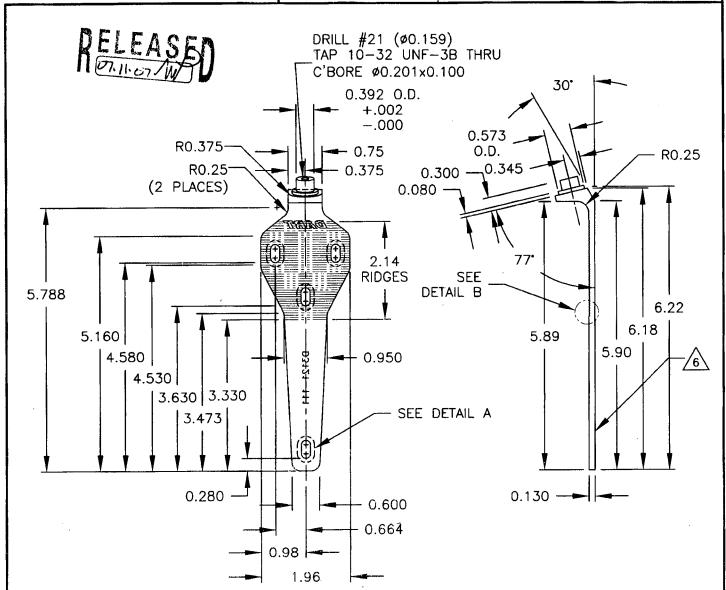


D3121-15 BRACKET (SHOWN) D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE = 150 ksi MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005



DESIGN	DRAWN BY	DART AEROSP HAWKESBURY, ONTARI	
CHECKED _	APPROVED	DRAWING NO.	REV. E
4		D3121	SHEET 7 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:2



D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)

MIN ULTIMATE TENSILE = 150 ksi

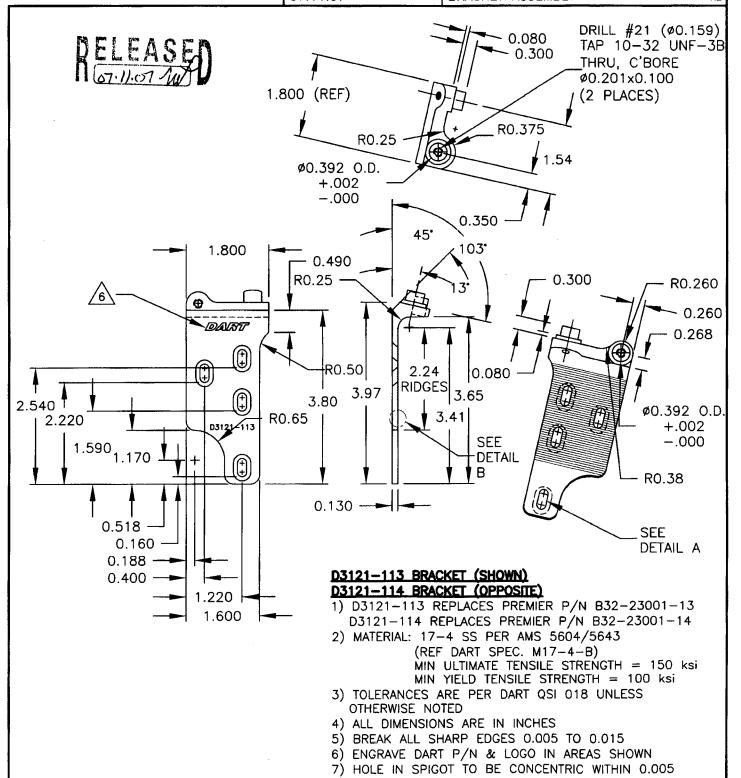
MIN YIELD TENSILE = 100 ksi

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

Copyright @ 2002 by DART AEROSPACE LTD

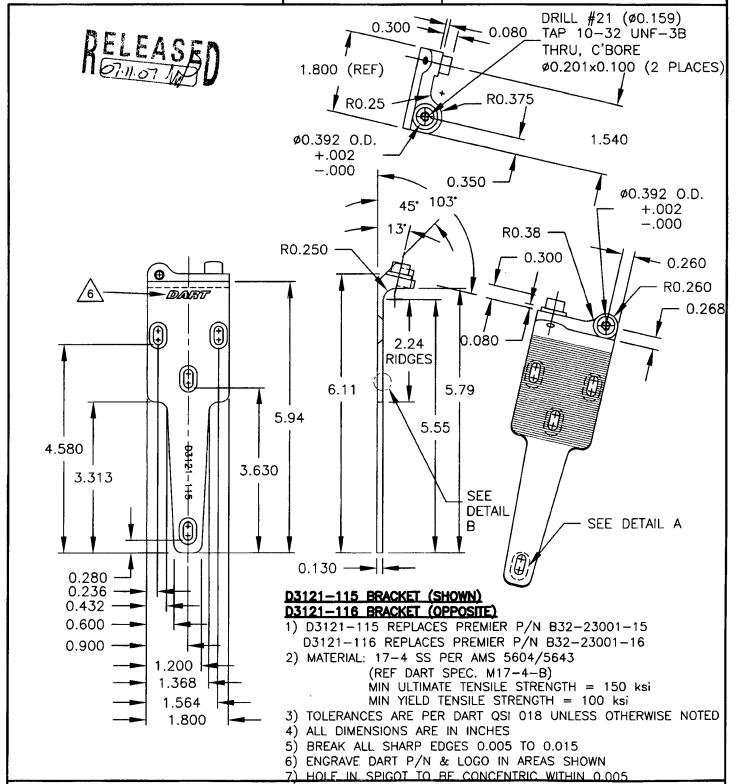


DESIGN	DRAWN BY	DART AEROS HAWKESBURY, ONTA	PACE LTD ARIO, CANADA
CHECKED _	APPROVED,	DRAWING NO.	REV. E
4	-#	D3121	SHEET 8 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:2





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECKED	APPROVED.	DRAWING NO.	REV. E SHEET 9 OF 10			
DATE		TITLE	SCALE			
07.11.07		BRACKET ASSEMBLY	1:2			

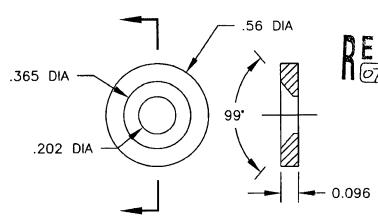


Sea with a sea to sent the season

Copyright © 2002 by DART AEROSPACE LTD

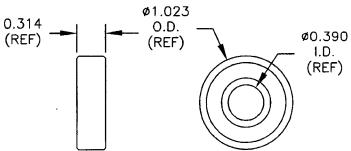


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECKED	APPROVED,	DRAWING NO.		REV. E	
#	#	D3121		SHEET 10 OF 10	
DATE		TITLE		SCALE	
07.11.07		BRACKET	ASSEMBLY	1:1	



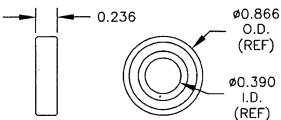
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCÈS ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE

0.375 -

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

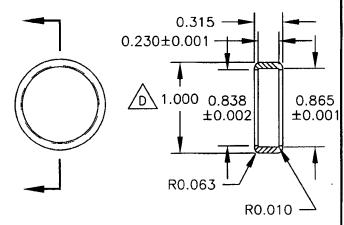
TAP 10-32

UNF-3A

0.050 TO 0.060

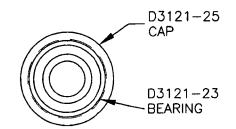
0.080

- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEBLY (SCALE 1:1)

Copyright © 2002 by DART AEROSPACE LTD

DART AEROSPACE LTD	Work Order:	107801
Description: Bracket	Part Number:	D3121-111
Inspection Dwg: D3121 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	, 392			mic	ZT-01
0.75	+/-0.030	.749			wer vern	ZT - 04
0.375	+/-0.010	.374				
2.14	+/-0.030	3.140				
1.96	+/-0.030	1.965				
0.280	+/-0.010	0.271				
3.330	+/-0.010	3.370				
3.630	+/-0.010	3.620				
R0.25	+/-0.030	. 250				
R0.375	+/-0.010	.375				
Ø0.201	+0.005/-0.001	,204				
0.100	+/-0.010	.102				
4.580	+/-0.010	4.570				
6.18	+/-0.030	6.177				
5.89	+/-0.030	5.878				
0.080	+/-0.010	.078				
0.300	+/-0.010	300				
30°	+/-0.1°	30°				
R0.25	+/-0.030	0.250				
0.130	+/-0.010	.136				
0.664	+/-0.010	-665				
0.381	+/-0.010	,360				
0.201	+/-0.010	,203				
0.400	+/-0.010	.397				
0.580	+/-0.010	.580				
100°	+/-0.1°	(သ°				
0.032	+0.000/-0.010	.032	DAS		-	

Measured by: Audited by: 27 Prototype Approval: N/A

Date: 13 10 17 Date: 11 Date: N/A

Date	Change	Revised by	Approved
04.01.12	New Issue P/O D3121-141	KJ/RF	
04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
06.06.14	Dwg Rev. updated	KJ/JLM	
08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	
08.05.28	Tolerance revised for Ø0.201 dimension	KJ/DD	<i>N</i>
(04.01.12 04.05.05 06.06.14 08.01.16	04.01.12 New Issue P/O D3121-141 04.05.05 Dimensions changed/re-arranged per Dwg revision 06.06.14 Dwg Rev. updated 08.01.16 Dimensions updated per Dwg Rev. E	04.01.12 New Issue P/O D3121-141 KJ/RF 04.05.05 Dimensions changed/re-arranged per Dwg revision KJ/JLM 06.06.14 Dwg Rev. updated KJ/JLM 08.01.16 Dimensions updated per Dwg Rev. E KJ/EC/DD